

Date: Monday, 07/07/2008 8:36:20 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FRONT OUTBOARD LEG (LH)		
Job Number	: 40313			Part Number	: D37683		
Estimate Number	: 13376			Drawing Number	: D3768 REVA		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/07/2008 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 30/07/2008 Qty: <i>3</i> Um: Each		
Previous Run	:						
Written By	:						
Checked & Approved By	<i>JUL 08.7.07</i>						
Comment	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T1000W065	6061T6 TUBE Comment: Qty.: 0.8969 f(s)/Unit Total : 0.8969 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <i>M006234</i>
2.0	DOOSAN LATHE	DOOSAN LATHE Comment: Doosan Lathe
		<i>Re 08/07/08</i>
1- Turn as per Folio FA757 Rev: <i>A</i> & Dwg D3768 Rev: <i>A</i>		
2-Deburr per dwg D3768		<i>Re 08/07/08</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK Comment: SECOND CHECK
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
		<i>J-F - 08/07/09/3</i>
		<i>08-07-09</i> <i>(X3)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 8:36:21 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT OUTBOARD LEG (LH)

Job Number: 40313

Part Number: D37683

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M 1 80 52



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 8:00 am

OVEN TEMPERATURE: 320°F

FINISH TIME: 8:30 am

8/08/07/15

AB

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



3X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 1 08/07/15

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST/15

10/07/15 (3)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/16 AB

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

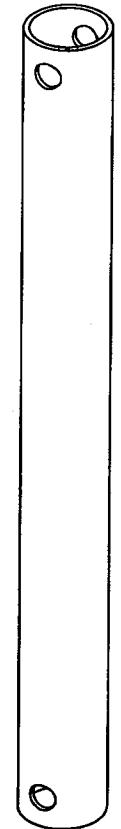
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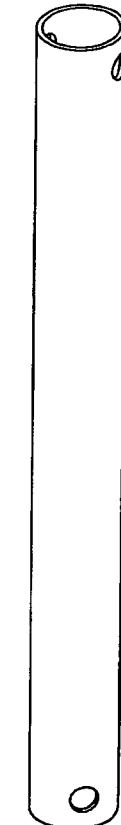
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D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH



D3768-4 FRONT OUTBOARD LEG, RH

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WITHOUT NOTICE
WORK ORDER
NO. 40313

RELEASED
R 08.06.16 100

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NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3768	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		FRONT LEG	NTS	
DATE	08.06.04		COPYRIGHT © 2008 BY DART AEROSPACE LTD	

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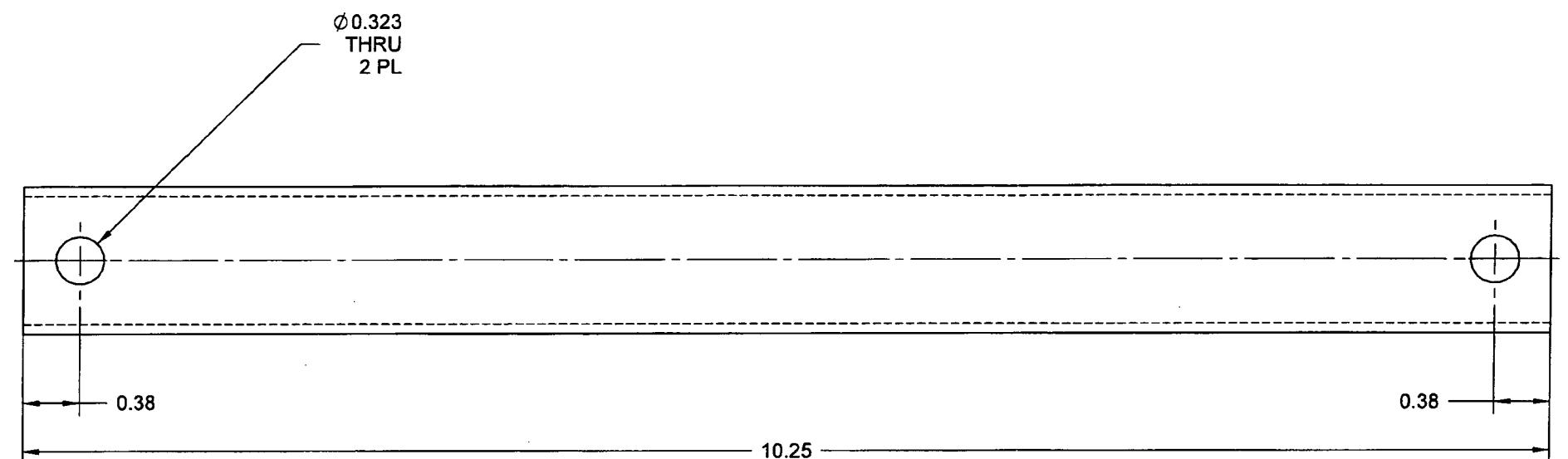
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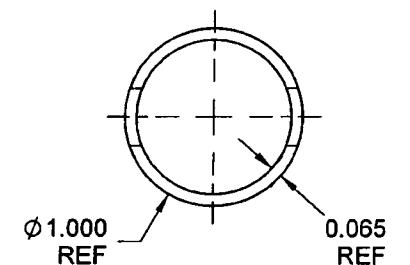
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D3768-1 FRONT INBOARD LEG



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MFG. APPR.	<u>MM</u>	D3768
APPROVED	<u>MM</u>	REV. A
DE APPR.	<u>MM</u>	SHEET 2 OF 4
DATE	08.06.04	TITLE
		FRONT LEG
		SCALE
		NTS

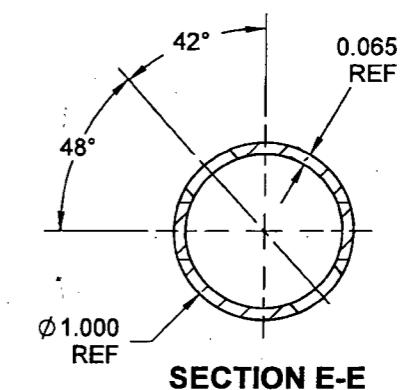
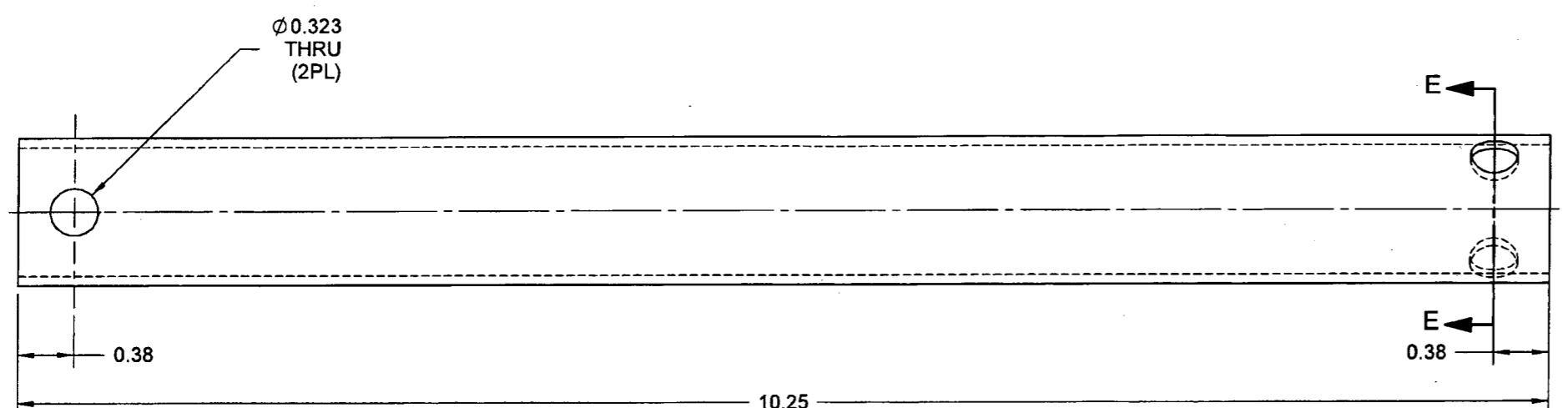
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8 7 6 5 4 3 2 1

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SECTION E-E

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NO. 10313

D3768-3 FRONT OUTBOARD LEG, LH

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06-16-04

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CHECKED	<i>PL</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>NA</i>	D3768	SHEET 3 OF 4
APPROVED	<i>ML</i>	TITLE	SCALE
DE APPR.	<i>ML</i>	FRONT LEG	NTS
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8 7 6 5 4 3 2 1

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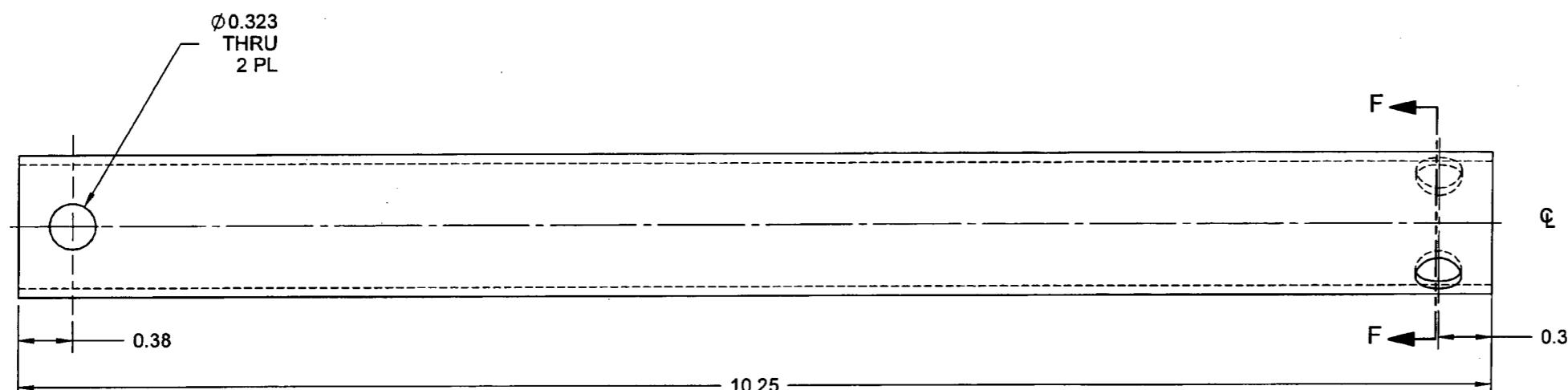
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D3768-4 FRONT OUTBOARD LEG, RH

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08.06.04

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MFG. APPR.	AC	D3768	REV. A
APPROVED	W	SHEET 4 OF 4	
DE APPR.	W	TITLE	SCALE
DATE	08.06.04	FRONT LEG	NTS

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DART AEROSPACE LTD	Work Order:	40313
Description: Crosstube Assembly <i>Front OutBoard Leg, LH</i>	Part Number:	D3768-3
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.323	.306 - .001	.325			
	.38	.371 - .030	.38			
	10.25	.11 - .030	10.24			
	.38	.371 - .030	.375			
	42°	.41 - 1/2°	42°			
	48°	.47 - 1/2°	48°			
	1.000	.47 - .010	1.000			
	.065	.061 - .000	.064			
SIDE B						

Measured by:	<i>Re</i>	Audited by:	J. F.	Prototype Approval:	N/A
Date:	08/07/08	Date:	08/07/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	<i>[Signature]</i>